Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18538-1
Job Sheet 189092

Part No: RBT18538-1 **Job Qty:** 20 ea
Part Name: Left Seat Brace

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 1/18/19 **Job Tracking No:**
Due Date: ~~2/15/19~~ March 18 **Created By:** Marie Lajeunesse
Type: Stock **Description:**
Note: DWG RBT18538 Rev2A IPP Rev A 17.12.13 New issue DP verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	**Waterjet - Flow - 1**	20 pcs		2/15/19	0.00	2.00	Waterjet - Flow		
110	**QC**	20 pcs		2/15/19	0.00	0.00	QC2 Waterjet-4	DAS	
120	**QC**	20 pcs		2/15/19	0.00	0.00	QC8-7	52	FEB 12 2019
130	**Brake NC**	20 pcs		2/15/19	0.00	5.00	Brake NC 1	9-89	DAS
140	**QC**	20 pcs		2/15/19	0.00	0.00	QC5		40 MAR 0 8 2019
150	**Outsource**	20 pcs		2/15/19			ATG001-VC		9-89
160	**Packaging**	20 pcs		2/15/19	0.00	0.00	Packaging2		MAR 15 2019
170	**QC**	20 pcs		2/15/19	0.00	0.00	QC6		MAR 18 2019 68
180	**Packaging**	20 pcs		2/15/19	0.00	0.00	Packaging3-1		28 21 9-89
190	**QC21-SA**	20 Ea		2/15/19	0.00	0.00	QC21		9-89 MAR 1 9 2019

Part Op Descriptions:
100 - 1-Cut as per Dwg (RED BARN FOLDER) Dwg Rev: 2A Prog Rev: 2A 2-Deburr if necessary
130 - Form as per DWG sheet 2
140 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
150 - -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.040	5052-H32 .040 Sheet	7.2000 sf (.36 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.040	7	19	0

Part Specifications

Specifications could not be found.

Plex 1/18/19 10:18 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	189092
Description: Left seat bracket		Part Number:	RBT18538-1
Inspection Dwg:	Rev: 2A		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.218	+/- .005	Ø.219	1		VDC02	
.332	+/- .005	.329	1			
.265	+/- .005	.264	1			
.357	+/- .005	.355	1			
17.52	+/- .010	17.52	1			
.04	+/- .010	.037	1			

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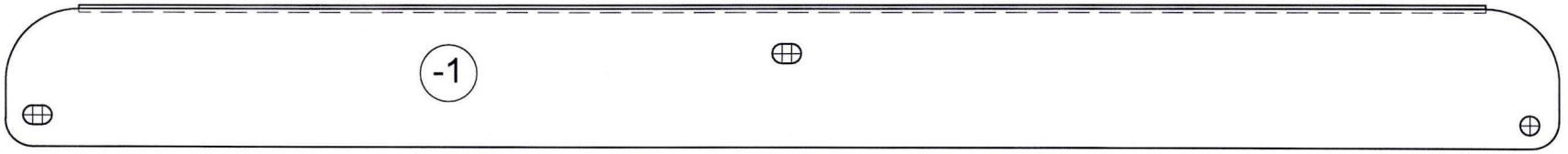
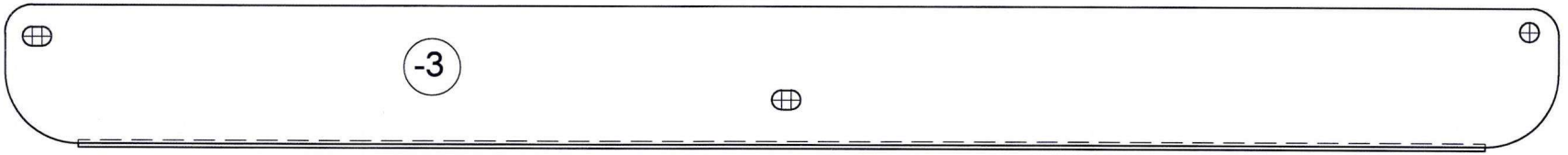
REVISIONS

REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ORIGINAL TOOL WAS A MACHINED SOLID PART, NOW A FORMED PART.	10/7/10	WP	
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO ø.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189092 MC
1901-18

Added B & L & 407 to used on model 3/20/12 after DW veified the hole pattern is the same. No rev done. RJC

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	LEFT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2
			-3	1	RIGHT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2
	ASSY #							

RED BARN MACHINE

TITLE: SEAT FRAME SUPPORTS

DWG NO. RBT18538 REV 2A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS .XXX ± .005 .XX ± .01 .X ± .1
METRIC REF. .XXmm ± .1mm
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

DRAWN BY: PERRITT
APPROVED: D Weil
HEAT TREAT
FINISH
SPEC
USED ON MODEL: BELL 206 B & L, 407

SCALE: NTS DATE: 10-7-10 SHEET: 1 of 2

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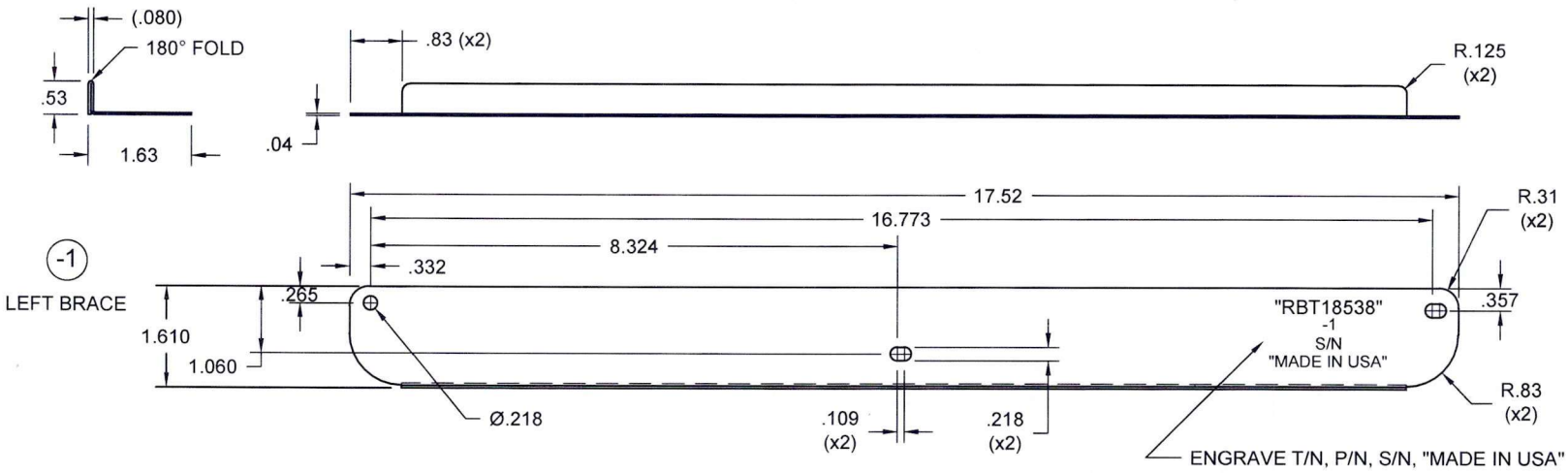
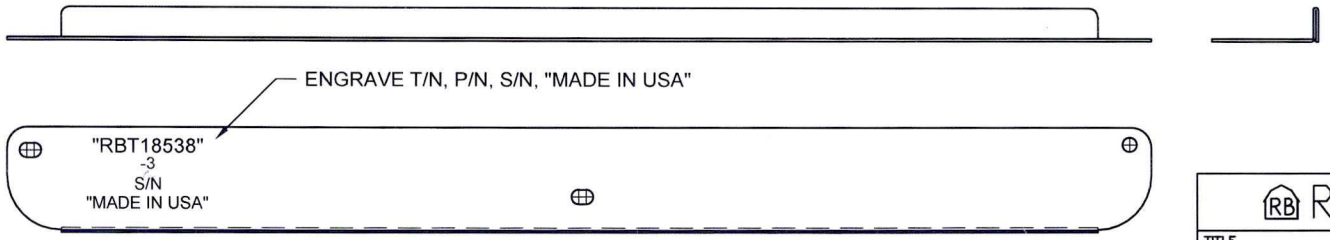
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO ø.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW





-3

RIGHT BRACE
(DIMENSIONALLY OPPOSITE LEFT BRACE)

RED BARN MACHINE

TITLE: SEAT FRAME SUPPORTS

DWG NO. RBT18538 REV 2A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS .XXX ± .005 .XX ± .01 .X ± .1
METRIC REF. .XXmm ± .1mm
FRACTIONS ± 1/32
ANGLES ± .5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

DRAWN BY: PERRITT
APPROVED: D. Weil
HEAT TREAT:
FINISH: CLEAR ANODIZE
SPEC: MIL-A-8625F, TYPE II, CLASS I
USED ON MODEL: BELL 206 B & L, 407

SCALE: NTS DATE: 10-7-10 SHEET: 2 of 2

Entered: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled
☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function
☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up
☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART AEROSPACE

Container No: S150046

Part: RBT18538-1
Job No: 189092
Serial No/Batch: S150046
Revision: 2A
Inspector:
Exp Date:
Instructions:

Date: 01/31/19

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO042839

Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042839
PO Date: 3/8/19
Due Date: 3/15/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191260	HT-900-NC-09A	Filter Base Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to GROUPE ALTECH PO: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed X4	-	3/15/19 MAR 14 2019	4 pcs	0 pcs DP	4 pcs	$3.72/pcs	$14.88

Line Item Note **Need back for March 15,2019**

Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO042839

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	189092	RBT18538-1	Left Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X2	-	3/15/19 MAR 15 2019	21 pcs	0 pcs DP	21 pcs	$3.72/pcs	$78.12
Line Item Note	**Need back for March 15,2019**										
3	186665	RBT18538-3	Right Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X10	-	3/15/19 MAR 15 2019	10 pcs	0 pcs DP	10 pcs	$3.72/pcs	$37.20
Line Item Note	**Need back for March 15,2019**										
4	189093	RBT18538-3	Right Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X9	-	3/15/19 MAR 15 2019	9 pcs	0 pcs DP	9 pcs	$3.72/pcs	$33.48
Line Item Note	**Need back for March 15,2019**										

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO042839

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	R190195	C2-1-1	Manual Release Knob (Outsource process- Anodize per QSI017 4.1.10.1)-Issue P/O to ATG : PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	3/15/19 MAR 15 2019	5 pcs	0 pcs	5 pcs	$3.72/pcs	$18.60
Line Item Note	**Need back for March 15,2019**										
6	R190194	4.5NR-32	Manual Release Knob RED ANODIZE PER MIL-A-8625 TY II CL 2	Firmed	-	3/15/19 MAR 15 2019	22 pcs	0 pcs	22 pcs	$3.72/pcs	$81.84
Line Item Note	**Need back for March 15,2019**										
7	186714	646.3012	Lower Guide Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	-	3/15/19	4 pcs	0 pcs	4 pcs	$21.32/pcs	$85.28
Line Item Note	**Need back for March 15,2019**										
8	187494	646.3012	Lower Guide Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	-	3/15/19	8 pcs	0 pcs	8 pcs	$21.32/pcs	$170.56
Line Item Note	**Need back for March 15,2019**										

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Canada

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PURCHASE ORDER
PO042839

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	190533	RBW109-3130-34-1-1	Cylinder, Ø2-5/8 X 4-1/2 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/15/19	5 pcs	0 pcs	5 pcs	$3.72/pcs	$18.60

XS MAR 14 2019 DP

Line Item Note **Need back for March 15,2019**

Grand Total: **$538.56**

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/14/19 3:07 PM dart.Lussier.Patrick

A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 917447 Date: 14-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery

Quantity	Description
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.
4 each	Part: HT-900-NC-09A Rev: 6E Filter Base Anodize per MIL-A-8625F, Type II, Class 2, Black, Water Sealant .0004-.0010" (.4 - 1 mils). Job: 24753 PO: PO042839 Line: 1
21 ea	Part: RBT18538-1 Rev: 2A Left Seat Brace Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24754 PO: PO042839 Line: 2
19 ea	Part: RBT18538-3 Rev: 2A Right Seat Brace Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24755 PO: PO042839 Line: 3-4
5 each	Part: C2-1-1 Rev: Manual Release Knob Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils) Water Sealant Job: 24756 PO: PO042839 Line: 5
22 each	Part: 4.5NR-32 Rev: 1 Manual Release Knob Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils) Water Sealant Job: 24757 PO: PO042839 Line: 6
5 ea	Part: RBW109-3130-34-1-1 Rev: Cylinder, Ø2-5/8 x 4-1/2

Made in Canada.

A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 917447 Date: 14-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery

Quantity	Description
	Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (4 - 1 mils)
	Job: 24759 PO: PO042839 Line: 9
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 14/3/19 Certified Signature: Receiver Signature: A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

Made in Canada.